

Date: \* Wednesday, 2/20/2008 4:27:40 PM  
 User: Kim Johnston

## Process Sheet

Customer	CU-DAR001	Dart Helicopters Services	Drawing Name	BASKET BASE ASSEMBLY
Job Number	37560B			
Estimate Number	10852			
P.O. Number	:		Part Number	D3324041
This Issue	2/20/2008	S.O. No. :	Drawing Number	D3324 UNDER REVIEW <i>PD 08-04-30</i>
Prsht Rev.	NC		Project Number	N/A
First Issue	/ /	Type :	Drawing Revision	B
Previous Run	37495B		Material	:
Written By	:		Due Date	3/30/2008
Checked & Approved By	<i>Hy 08 02 21</i>		Qty:	1
Comment	Est Rev:A 05.02.09 New issue KJ/JLM			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	D33283	Basket Hinge	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2	D3328-3 Hinge Plate	<i>B34124</i>
			<i>PD 08-04-30</i>
2.0	D33481	Clevis	
		Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	4	D3348-1 Clevis	<i>B37583</i>
			<i>PD 08-04-30</i>
3.0	D33493	Spacer Bushing	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2	D3349-3 Spacer Bushing	<i>B38178</i>
			<i>PD 08-04-30</i>
4.0	D33671	Mounting Bracket	
		Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)	
		Pick:	
		Qty Part Number Description Batch	
	2	D3367-1 Mounting Bracket	<i>B38179</i>
			<i>PD 08-04-30</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/20/2008 4:27:40 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 37560B

Part Number: D3324041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 M4130NTS0500W035 4130 Square tube .5 x .5



Comment: Qty.: 48.9300 f(s)/Unit Total : 48.9300 f(s)

Material: 4130 Cond. N Square tube per MIL-T-6736,

1/2" x 0.035" wall

M4130N-TS0.500W.035)

PD 0304-30

6.0 M569EX05018F 569 Expanded Metal



Comment: Qty.: 28.0000 sf(s)/Unit Total : 28.0000 sf(s)

Pick:

Qty Part Number Description

Batch

28s M569EX0.50-18F 1/2"-18gauge(.040") carbon steel

M107676

M10774

08-04-30

7.0 LARGE FAB 1, LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut tubes as per Dwg D3324

Qty Part Number Description Batch

3 D3324-1 Bottom Tube M104695 => 42"

4 D3324-3 Full Length Tube M104695 => 86.5" / M107721 => 259.5"

2 D3324-5 Top End Tube M107721 => 32"

2 D3324-7 Bottom EndTube M104695 => 91.2" M107721 => 30"

10 D3324-9 Vertical Tube M107721 => 22.5" M104695 => 91.2"

Identify parts appropriately

2-Remove all markings from material & check for foreign objects

3-Drill and Weld as per Dwg D3324 & QSI 004 using DT8781 A & B

A/R/N/Steel Rod M100075

4-Deburr as required

PD 0304-30

8.0 QC9 VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

1103/04/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY

Job Number: 37560B

Part Number: D3324041

Job Number:



Seq. #: Machine Or Operation:

Description:

9.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/04/30 (A)

37560B  
D3324041  
30/04/2008

10.0 POWDER COATING

POWDER COATING



M107550

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

08.04.30

S.160 13.20  
#1 396.4 F  
#2 300 F  
#3 4 F  
#4 4 F

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08.04.30 (A)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



37560

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

13.0 QC21

FINAL INSPECTION/W/O RELEASE



08/04/30 (A)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



08.04.30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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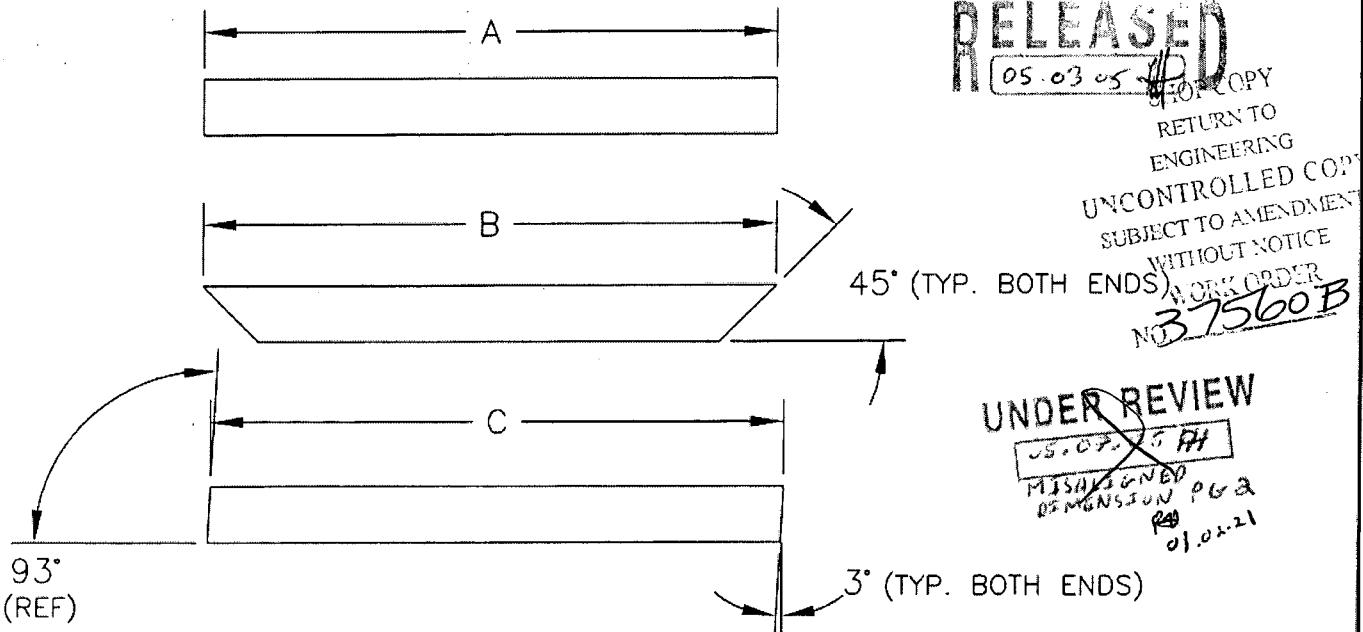
NOTE: Date & initial all entries

**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO.	D3324	REV. B SHEET 1 OF 3
DATE	TITLE			SCALE NTS
05.03.04	BASKET BASE ASSEMBLY			
A	04.10.20	NEW ISSUE		
B	05.03.04	UPDATE MESH MATERIAL SPEC		

PARTS LIST FOR D3324-041 BASKET BASE ASSEMBLY

Part No.	Quantity (-041)	Length A	Length B	Length C	Description
D3324-1	3	14.00	N/A	N/A	BOTTOM TUBE
D3324-3	4	N/A	86.50	N/A	FULL LENGTH TUBE
D3324-5	2	N/A	16.00	N/A	TOP END TUBE
D3324-7	2	N/A	15.00	N/A	BOTTOM END TUBE
D3324-9	10	N/A	N/A	11.04	VERTICAL TUBE
D3328-3	2	N/A	N/A	N/A	HINGE PLATE
D3348-1	4	N/A	N/A	N/A	CLEVIS
D3349-3	2	N/A	N/A	N/A	SPACER BUSHING
D3367-1	2	N/A	N/A	N/A	Mounting Bracket



D3324-1/-3/-5/-7/-9

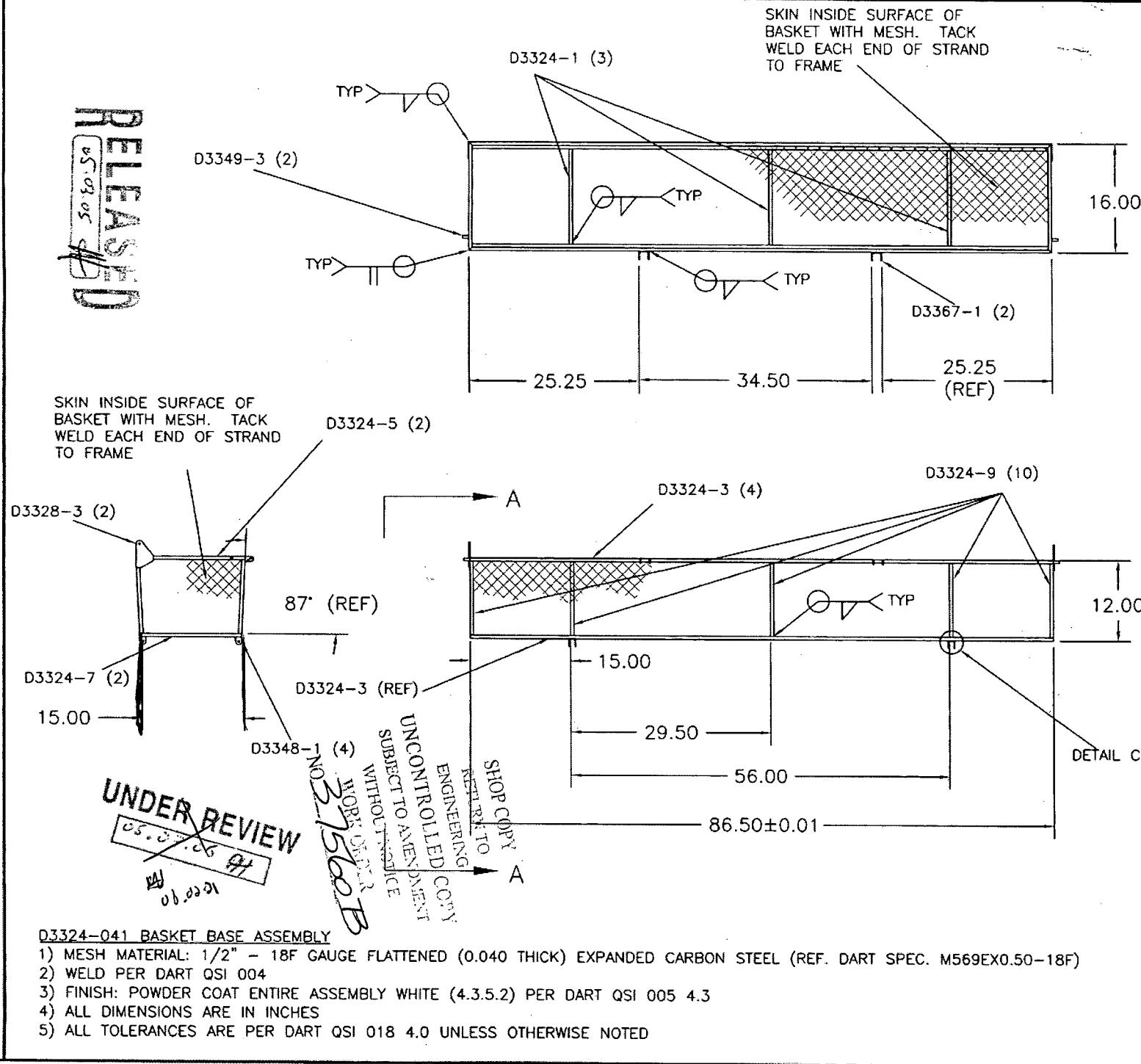
- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) MATERIAL: 4130 COND. N SQ. TUBE PER MIL-T-6736, 1/2" SQ. x 0.035 WALL (REF. DART SPEC M4130N-TS0.500W.035)
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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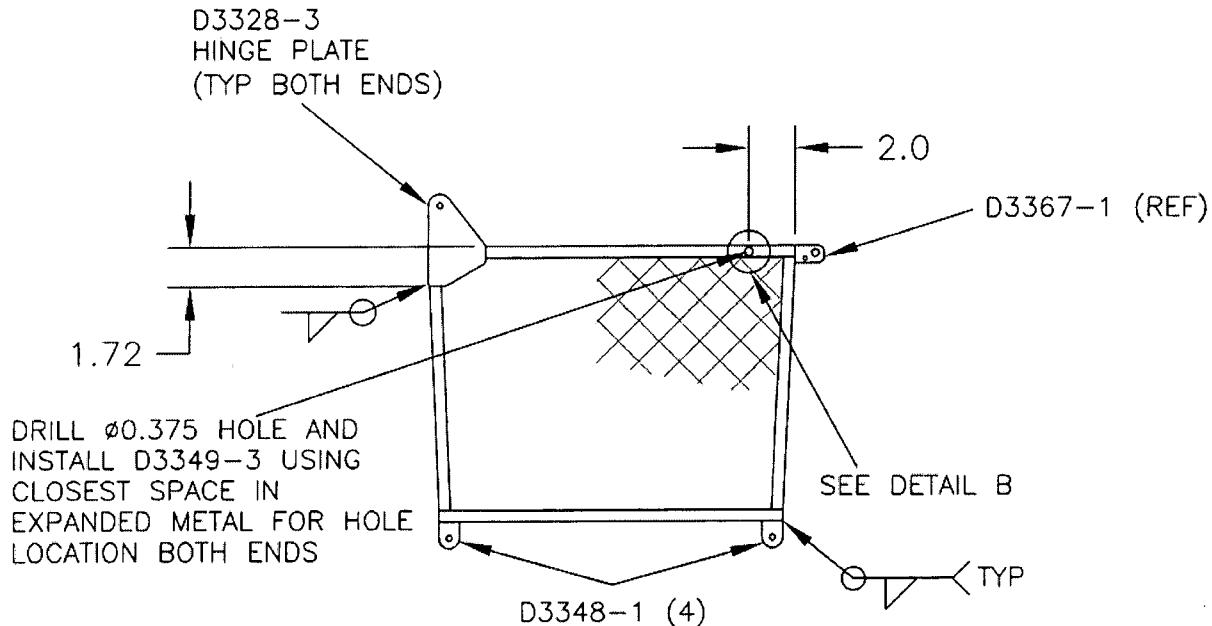
**DART**

DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD
CHECKED <i>PH</i>	APPROVED <i>PH</i>	HAWKESBURY, ONTARIO, CANADA
DATE 05.03.04	DRAWING NO. D3324	REV. B
TITLE BASKET BASE ASSEMBLY	SHEET 2 OF 3	SCALE 1:20

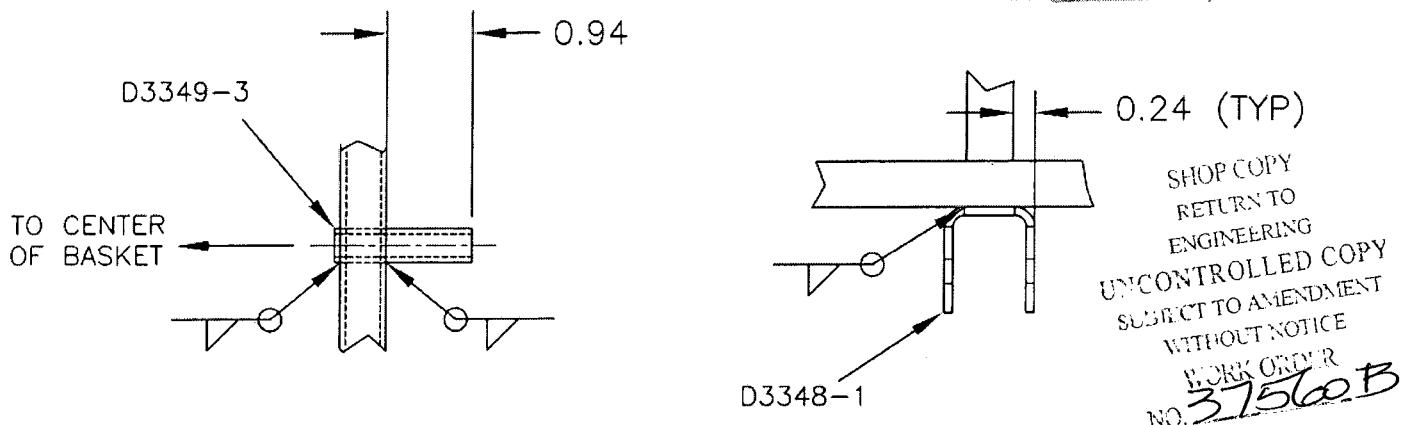




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CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3324
DATE 05.03.04		REV. B SHEET 3 OF 3 TITLE SCALE 1:8 BASKET BASE ASSEMBLY



RELEASED  
05.03.05 *PH*



DETAIL B  
(SCALE 1:2)

DETAIL C  
(SCALE 1:2)

UNDER REVIEW  
05.03.05 *PH*  
03.02.1